

Date: Monday, 4/23/2007 1:52:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 31990	
Estimate Number : 12736	
P.O. Number : N/A	Part Number : D353515
This Issue : 4/23/2007 S.O. No. : N/A	Drawing Number : D3535 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A B PH 07.04.28
Previous Run : 30750	Material : N/A
Written By : <u>JA 07.04.26</u>	Due Date : 4/30/2007 Qty: <u>25</u> Um: Each
Checked & Approved By : <u>JA 07.04.26</u>	
Comment : Est Rev: A New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total : 21.4305 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M/01873

SAD 07/04/28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

SAD 07/04/28

(26)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/28

(26)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/04/30

(25)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-15

SB 07/04/30

(26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/05/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31990

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



207-05-01 (26)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M1101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

281

07-05-03

(26)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(26X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/05/04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(26X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-15

m-l 07/05/04

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(26)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/04

Job Completion



u 07.05.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

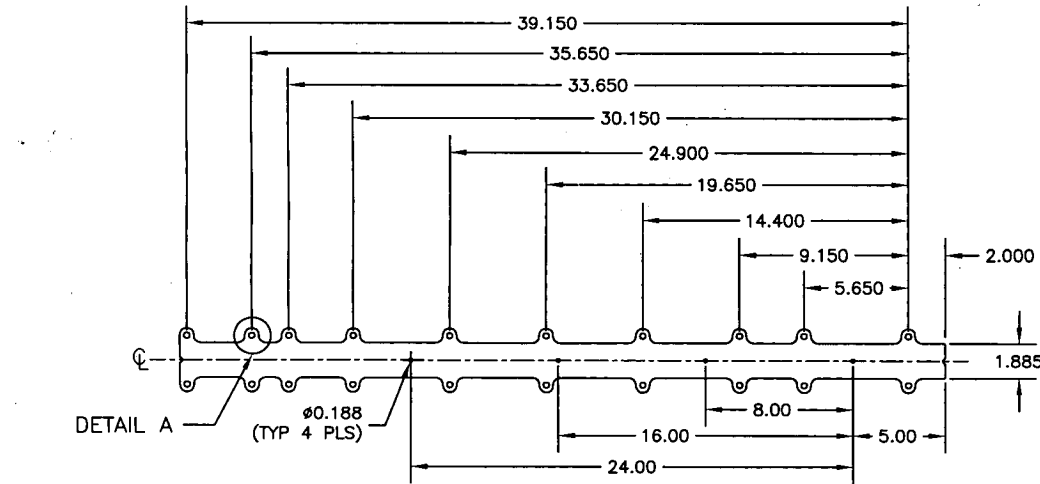
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

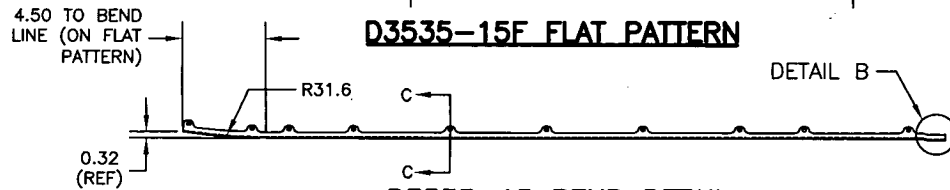
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

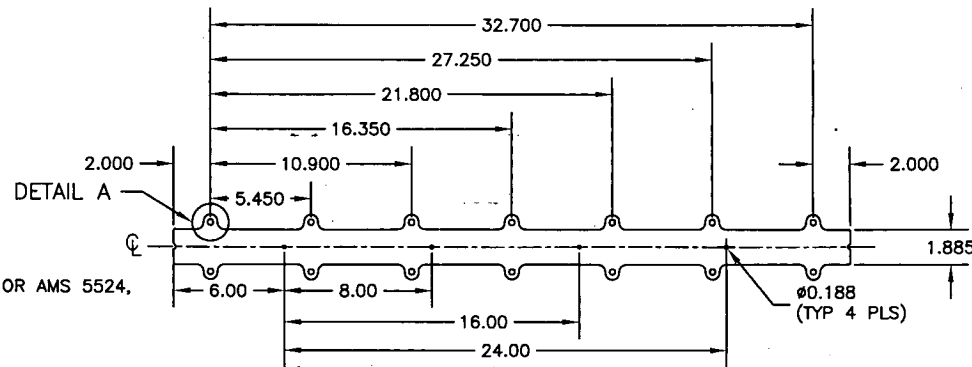


D3535-15F FLAT PATTERN

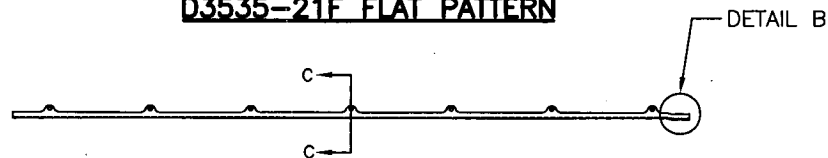


D3535-15 BEND DETAIL

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 31990



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

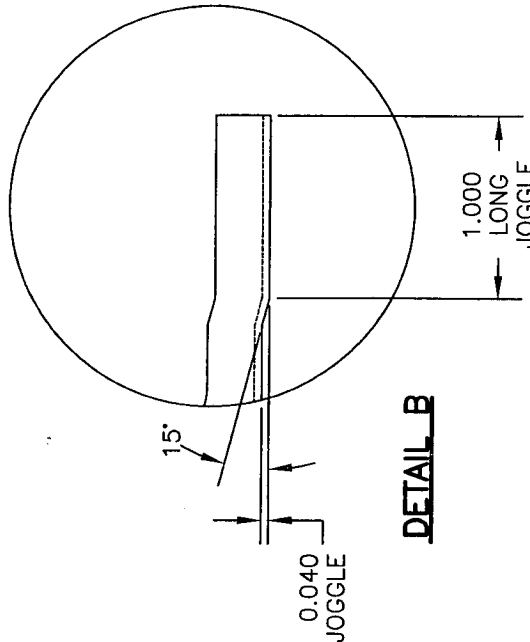
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

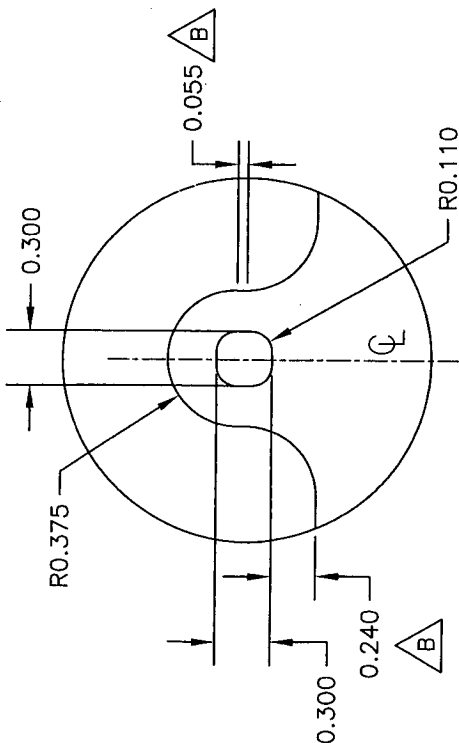
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO. D3535	SHEET 2 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10	

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

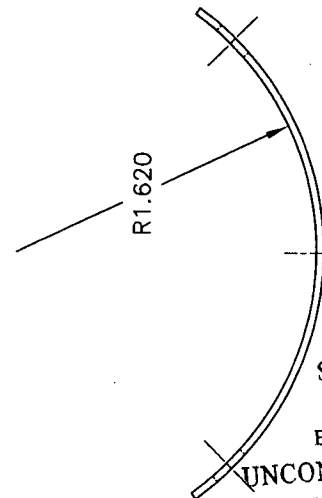
PRELIMINARY ISSUE



DETAIL B



DETAIL A



SECTION C-C

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **31990**

DART AEROSPACE LTD		Work Order: 31991
Description: WEARSHOE		Part Number: D 353521
Inspection Dwg: D 3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.885	± 0.010	1.888	✓	Vern	
B	2.000	± 0.010	2.005	✓	Vern	
C	5.650	± 0.010	5.648	✓	Vern	
D	9.150	± 0.010	9.150	✓	M-T	
E	14.400	± 0.010	14.400	✓	M-T	
F	19.650	± 0.010	19.650	✓	M-T	
G	24.900	± 0.010	24.900	✓	M-T	
H	30.150	± 0.010	30.150	✓	M-T	
I	33.650	± 0.010	33.650	✓	M-T	
J	35.650	± 0.010	35.650	✓	M-T	
K	39.150	± 0.010	39.150	✓	M-T	
L	$\varnothing 0.188$	$+0.005$ -0.001	$\varnothing 0.188$	✓	Vern	
M	24.00	± 0.030	24.00	✓	M-T	
N	16.00	± 0.030	16.00	✓	M-T	
O	8.00	± 0.030	8.00	✓	M-T	
P	5.00	± 0.030	5.007	✓	Vern	
Q	0.300	± 0.010	0.300	✓	Vern	
R	0.300	± 0.010	0.297	✓	Vern	
S	0.034 0.038	± 0.010	0.036	✓	Vern	
T						
U						
V						
W						
X						
Y						

Measured by: JAD	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/04/21	Date: 07/04/20	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved